

In the Claims:

1. **(Currently Amended)** A method of extruding structural members comprising:(a) providing an alloy comprising consisting essentially of:
 - about 3.6 to about 4.2 wt % copper,
 - about 1.0 to about 1.6 wt % magnesium,
 - about 0.3 to about 0.8 wt. % manganese,
 - about 0.05 to about 0.25 wt. % zirconium,
 - not more than about 0.08 wt.% iron,
 - not more than about 0.06 wt.% silicon

the balance substantially aluminum, incidental elements, and impurities;

(b) homogenizing said alloy at a temperature between about 855° and 880°F prior to extruding said alloy at an extrusion billet temperature within about 500° to about 750°F to form an extrusion;

(c) solution heat treating said extrusion; and

quenching said extrusion before making a structural member therefrom.
2. **(Currently Amended)**The method of claim 1 wherein the extruding extrusion billet temperature in step (b) is about 550° to about 650°F.
3. **(Currently Amended)** The method of claim 1 wherein the extruding extrusion billet temperature in step (b) is about 600° to about 650°F.
4. **(Original)** The method of claim 1 which further includes:
 - (e) stretching said extrusion by at least about 1 %.
5. **(Previously Presented)** The method of claim 27 which further includes:
 - (e) stretching said extrusion between about 1 to about 10%.
6. **(Previously Presented)** The method of claim 27 which further includes:
 - (e) stretching said extrusion between about 1 to about 8%.
7. **(Previously Presented)** The method of claim 27 which further includes:
 - (e) stretching said extrusion between about 1 to about 3%.

8. **(Previously Presented)** The method of claim 27 which further includes:

 (e) stretching said extrusion by at least about 1 %, said extrusion having less than about 50% by volume recrystallized after stretching.

9. **(Previously Presented)** The method of claim 27 which further includes in step (e):

 (e) stretching said extrusion by at least about 1 %, said extrusion being substantially unrecrystallized.

10. **(Previously Presented)** The method of claim 27 which further includes in step (e):

 (e) stretching said extrusion by at least about 1 %, said extrusion having a longitudinal yield strength of at least about 50 ksi and a longitudinal tensile ultimate strength of at least about 70 ksi.

Claims 11-26 Cancelled

27. **(Currently Amended)** A method of extruding structural members consisting essentially of:

 (a) providing an alloy comprisingconsisting essentially of:

 about 3.6 to about 4.2 wt % copper,
 about 1.0 to about 1.6 wt. % magnesium,
 about 0.3 to about 0.8 wt % manganese,
 about 0.05 to about 0.25 wt.% zirconium,
 not more than about 0.08 wt.% iron,
 not more than about 0.06 wt.% silicon,
 the balance substantially aluminum, incidental elements, and impurities;

 (b) extruding said alloy at an extrusion billet temperature within about 500° to about 750°F to form an extrusion;

 (c) solution heat treating said extrusion;

 (d) quenching said extrusion before making a structural member

therefrom; and

(e) stretching said extrusion by at least about 1 %.

28. **(Currently Amended)** A method of extruding structural members having a combination of high strength and toughness, said method comprising:

(a) providing an alloy comprisingconsisting essentially of:

about 3.6 to about 4.2 wt. % copper,
about 1.0 to about 1.6 wt. % magnesium,
about 0.3 to about 0.8 wt. % manganese,
about 0.05 to about 0.25 wt.% zirconium,
not more than about 0.08 wt.% iron,
not more than about 0.06 wt.% silicon,
the balance substantially aluminum, incidental elements, and impurities;

(b) homogenizing said alloy at a temperature between about 855° and 880°F prior to extruding said alloy at an extrusion billet temperature within about 500° to about 750°F to form an extrusion;

(c) solution heat treating said extrusion; and

(d) quenching said extrusion before making a structural member therefrom.